



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

D3065-3
Job Sheet 173417



Part No: D3065-3

Job Qty: 60 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/9/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		3/8/18	0.00	0.00	Start Up Waterjet		SA 18/03/05
100	Waterjet	60 pcs		3/8/18	0.00	2.76	Waterjet1		SA 18/03/05
120	QC	60 pcs		3/8/18	0.00	0.00	QC8		38
140	Brake NC	60 pcs		3/8/18	0.02	2.82	Brake NC 1		DAG-88 38
150	QC	60 pcs		3/8/18	0.00	0.00	QC5		38
160	HandFinish	60 pcs		3/9/18	0.00	1.23	HandFinish1		SA 18-3-12
170	QC	60 pcs		3/9/18	0.00	0.00	QC7-1		11
180	Packaging	60 pcs		3/9/18	0.00	0.00	Packaging3-1		MAR 13 2018
190	QC21-SA	60 Ea		3/9/18	0.00	0.00	QC21		GA 11/6

2 2018

Part Op 100 - 1-Cut as per Dwg Rev: B
Descriptions: 140 - Bend as per Dwg D3065
180 - LOCATION : GA

DAG 21 MAR 14 2018
9-88

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	13.0680 sf (.2178 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	13	88	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	1.260inches $\pm$ 0.010	1.270 1.250	1,261	
2	Step Spacer	3.260inches $\pm$ 0.010	3.270 3.250	3,261	
3	Step Spacer	5.260inches $\pm$ 0.010	5.270 5.250	5,262	
4	Step Spacer	6.520inches $\pm$ 0.010	6.530 6.510	6,522	
5	Step Spacer	2.093inches $\pm$ 0.010	2.103 2.083	2,095	
6	Step Spacer	3.936inches $\pm$ 0.010	3.946 3.926	3,938	
7	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176	4,185	
8	Step Spacer	0.129inches + 0.005 - 0.000	0.134 0.129	0,129	
9	Step Spacer	1.250inches + 0.005 - 0.000	1.255 1.250	1,250	
10	Step Spacer	1.204inches $\pm$ 0.005	1.209 1.199	1,205	
11	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030	0,040	

Plex 3/1/18 1:54 PM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								